

Work Order ID 74309-2

Wednesday, September 28, 2011 11:35:28 A

Page 1

Item ID: D3690-041

Accept

Revision ID:

Item Name: Glareshield Assembly

Start Date: 9/28/2011 Start Qty: 2.00

Required Date: 10/14/2011 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan: M.L.J

Date: 9/29/11 Tooling:

QC:

Date: SPC (Y/N):

Cust Item ID:

Customer:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3690

Rev C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- transfer drill D3697-041 and D3698-1 in D3690-1 and assemble as per dwg D3690

2- scribe batch # and part # as per dwg

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

(2) FF 12-03-19

(2) FF 12-03-19

12-03-19 (2)

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Item ID: D3690-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Glareshield Assembly

Start Date: 9/28/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



SprayPaint

SprayPaint

Memo

0.00

Spray Painting

1- Mask hatched areas (6 pls) on inside of the part prior to painting as per dwg

2-Paint D3690-041 assy flat black using Basf Glasurit 22 Line code SFA39.50 per Dart QSI 005 4.2

AS 12 - 3 - 28 ①

140

0.00



QC14- Inspect Spray Paint

QC

Memo

0.00

Quality Control

PM 74308
12/4/12

W 12. 04. 02 ①

160

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

MLJ 12/04/03
MF
12-04-02

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Start Date: 9/28/2011

Required Date: 10/14/2011

Start Qty: 2.00

Required Qty: 2.00

Comments:	IPP Rev:A	08-04-29	new issue	DD	verified by:ec
	IPP Rev:B	08-07-14	revB as per dwg	DD	verified by:ec
	IPP Rev:C	08-09-08	added painting	DD	verified by:EC
	IPP Rev:D	08-10-07	revC as per dwg	DD	verified by:EC

<u>Component Item ID/ Item Name</u>	<u>Replacement Item ID</u>	<u>Mfg/ Purch</u>	<u>Bin Item</u>	<u>Primary Location</u>	<u>Last Location</u>	<u>Route Seq ID</u>	<u>Unit of Measure</u>	<u>Qty on Hand</u>	<u>Qty per Kit</u>	<u>Total Qty</u>	<u>Qty Issued</u>	<u>Date Issued</u>	<u>Status</u>
AN960JD3		Purchased	No				Each	145.0000		4			
										4	(2)	FF 12-03-19	
Washer													
<u>Location</u>							<u>Loc Qty</u>	<u>Loc Code</u>					
								ST346	145				
								107989	145				
CR3213-4-p3		Purchased	No				Each	100.0000		70			
										72	(2)	FF 12-03-19	
rivet													
<u>Location</u>							<u>Loc Qty</u>	<u>Loc Code</u>					
								MEZZ	100				
								116081	100				
D3690-1		Manufactured	No				Each	0.0000		2			
Glareshield													
D3697-041		Manufactured	No				Each	0.0000		2			
										2	(2)	FF 12-03-19	
Tube Assembly													
D3698-1		Manufactured	No				Each	7.0000		2			
										2	(2)	FF 12-03-19	
Support Angle													
<u>Location</u>							<u>Loc Qty</u>	<u>Loc Code</u>					
								ST241A	7				
								41656	2				
								59244	5				

Picklist Print

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Work Order ID: 74309

Parent Item: D3690-041

Parent Item Name: Glareshield Assembly



Start Date: 9/28/2011

Required Date: 10/14/2011

Start Qty: 2.00

Required Qty: 2.00

MS20426AD3-5

Purchased

No

Each

13,156.00

4



Rivet



② FF 12-03-19

Location

Loc Qty

Loc Code

ST316

13156

4179

1342

4444

5654

4533

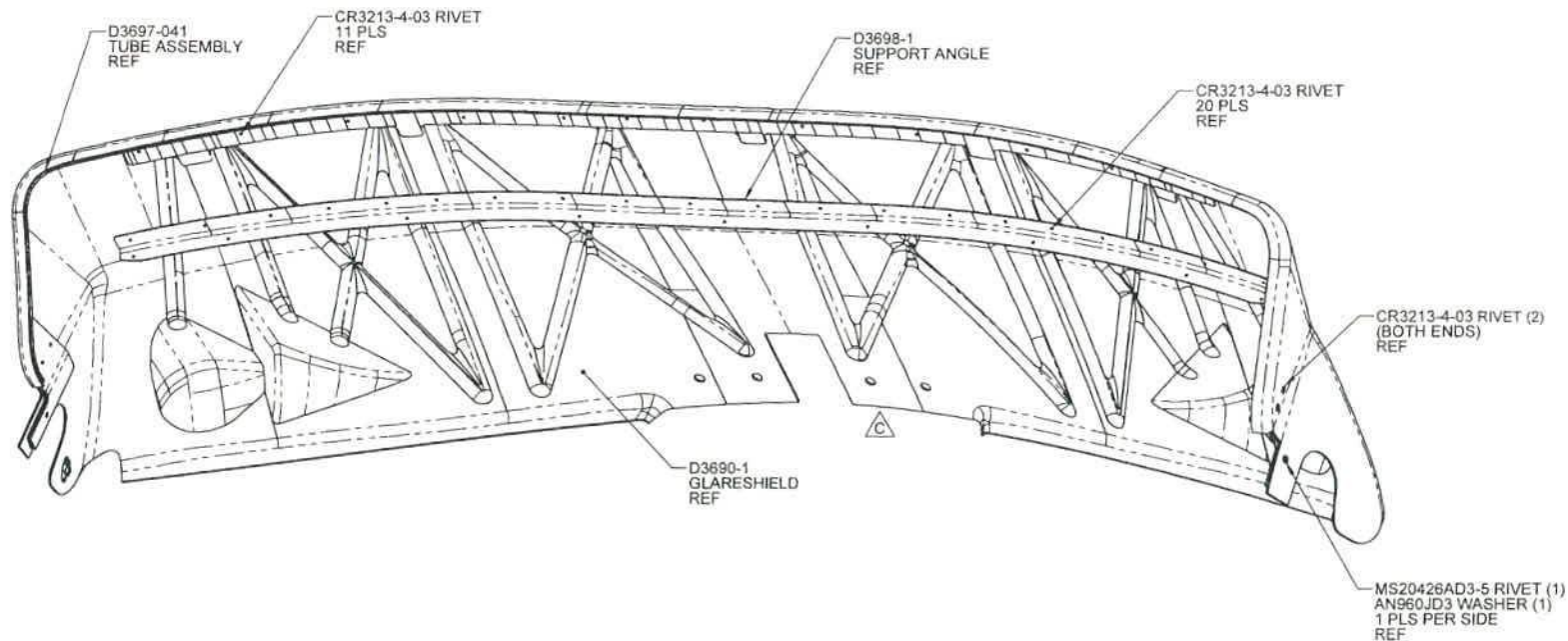
6160

4

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Shop Packet Print

Page 2



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3690-041	GLARESHIELD ASSEMBLY
1	D3690-1	GLARESHIELD
1	D3697-041	TUBE ASSEMBLY
1	D3698-1	SUPPORT ANGLE
2	AN960JD3	WASHER (OR NAS1149DN332J)
2	MS20426AD3-5	RIVET
35	CR3213-4-03	RIVET

D3690-041 GLARESHIELD ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74309 M.C.J.

RELEASED
2009/11/11

C	SHEET 1 PL MS20426AD3-5 RIVET WAS MS20426AD3-4, CR3213-4-03 RIVET WAS MS20470AD3-4, WASHER QTY WAS 6 (VIEWS UPDATED ACCORDINGLY). RIVETS ON SHEET 1 CHANGED TO REF QTY. RIVETS ON SHEET 2 CHANGED TO "HARD" CALLOUTS. SHADING REMOVED FROM ALL VIEWS FOR CLARITY.	AJS	08.09.02
B	ADD FINISH COAT & 1.0 TYP. SHEET 2 ZONES A, B & C, 5; ADD MIN THICKNESS. SHEET 3 ZONE A, B	RF	08.08.24
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3690	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	GLARESHIELD ASSEMBLY	NTS
DATE	08.09.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

91 29/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

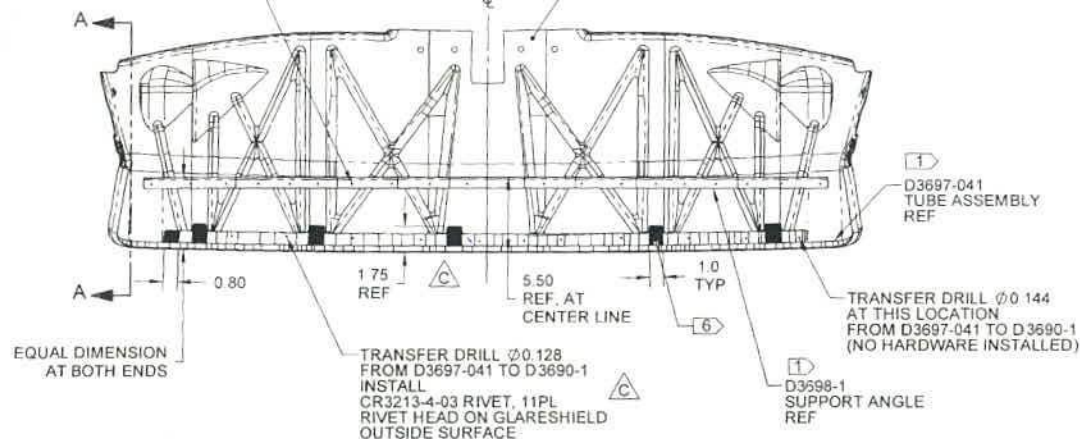
74309

TRANSFER DRILL $\varnothing 0.128$
FROM D3698-1 TO D3690-1
INSTALL
CR3213-4-03 RIVET, 20 PL
RIVET HEAD ON GLARESHIELD
OUTSIDE SURFACE

D3690-1
GLARESHIELD
REF

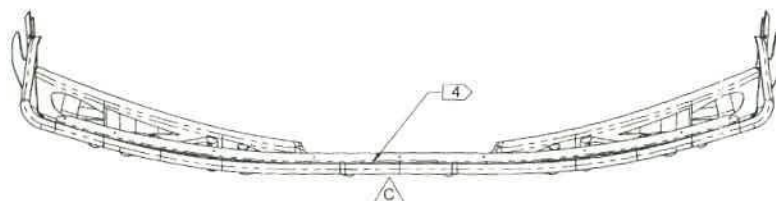
TRANSFER DRILL $\varnothing 0.098$
FROM D3697-041 TO D3690-1
INSTALL
MS20426AD3-5 RIVET
AN960JD3 WASHER (ON GLARESHIELD
OUTSIDE SURFACE)
1 PER SIDE

TRANSFER DRILL $\varnothing 0.128$
FROM D3697-041 TO D3690-1
INSTALL
CR3213-4-03 RIVET 2
BOTH ENDS



0.14
REF

SECTION A-A



D3690-041 GLARESHIELD ASSEMBLY

NOTES:

- 1) CENTER D3697-041 AND D3698-1 ON TO D3690-1
- 2) FINISH: PAINT D3690-041 ASSY FLAT BLACK USING BASF GLASURIT 22 LINE CODE SFA39.50 PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFICATION: ETCH WITH DART P/N D3690-041 & B/N ON INSIDE OF PART
- 5) WEIGHT: 2.98 lbs
- 6) MASK HATCHED AREAS (6 PLS) ON INSIDE OF THE PART PRIOR TO PAINTING

RELEASED
08-09-02

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG APPR		D3690	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR		GLARESHIELD ASSEMBLY	NTS
DATE	08.09.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

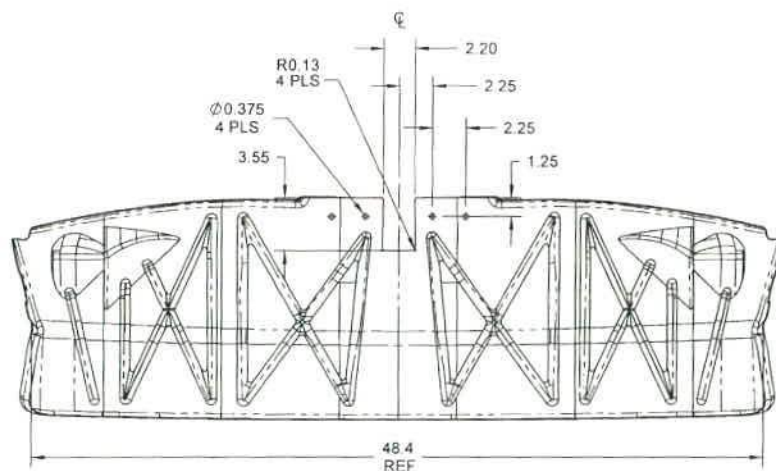
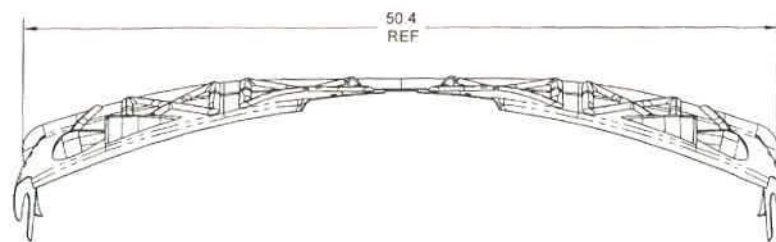
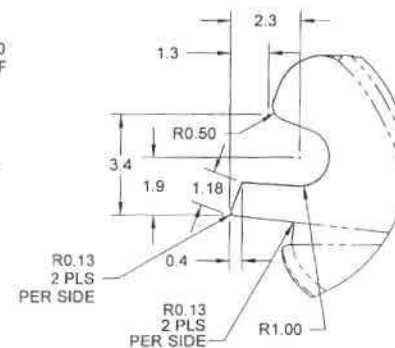
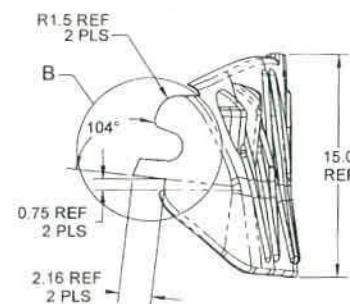
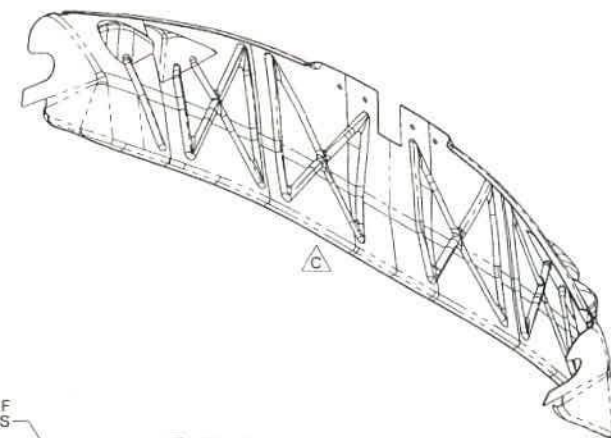
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74309

**D3690-1 GLARESHIELD****NOTES:**

- 1) MATERIAL: F6006 SUEDE/POLISHED 701 BLACK FLAT LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS 093-F6006-02)
- 2) TOOLING: THERMOFORM PER MOLD DT9010 PER QSI 022
TRIM PER MOLD SCRIBE LINES EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 2.5 lbs
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.040

RELEASED**DETAIL B**
SCALE 2X
THIS VIEW FOR REFERENCE ONLY

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO	REV. C
MFG. APPR.		D3690	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GLARESHIELD ASSEMBLY	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries